

Date: Wednesday, 12/7/2005 3:43:20 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : DOUBLER
<b>Job Number</b> : 25156	
<b>Estimate Number</b> : 10227	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D2151
<b>This Issue</b> : 12/7/2005 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2151 REV. A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 12/7/2005 <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 24493	<b>Material</b> : N/A
<b>Written By</b> : <u>SEE COMMENT BELOW</u>	<b>Due Date</b> : 12/15/2005
<b>Checked &amp; Approved By</b> : <u>SEE ABOVE. USER &amp; DATE</u>	<b>Qty:</b> 25 <b>Um:</b> Each
<b>Comment</b> : Est C 00.10.23 Re-format (mpp 2101) EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M2024T3S040	2024-T3 .040 sheet
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**Comment:** Qty.: 0.0368 sf(s)/Unit Total : 0.9188 sf(s)  
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick  
 (M2024T3S.040)

Batch:

M19059  
M19295

FF 05.12-07

25

2.0 \* SHEAR

SHEAR



**Comment:** SHEAR  
 Cut blank: 2.194" x 2.300" +/-0.005"

FF 05-12-07

25

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio FA110 and Dwg D2151  
 Identify as D2151

made by Rand

FF 06.04.10

25

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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N/A

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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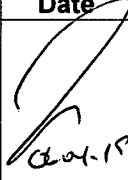
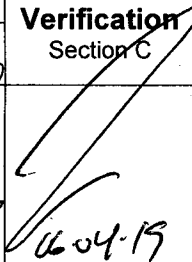

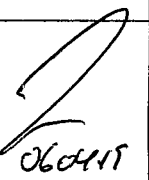
**Comment:** SECOND CHECK

QC5  
for  
06.04.19

19  
 25  
 P10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: DP Date: 0604/24  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0604-15	3	6 parts scrap. - 058 holes off by 1/2 the hole. CMC Part made by hand.		Scrap: destroy no replace.	 06-04-15	 06-04-15		 06-04-15

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 25156

Part Number: D2151

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

FF 06.04.19

19

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DC 06/04/22

(19)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DC 06/04/22

(19)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

16/4/24

(19)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST26

16/4/24

(19)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

22 06/04/24

(19)

Job Completion



12 06.04.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	25156
<b>Description:</b> Packer	<b>Part Number:</b>	D2151
<b>Inspection Dwg:</b> D2151 <b>Rev:</b> A		<b>Page 1 of 1</b>

## FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**      ☐ **Prototype**

[illegible]

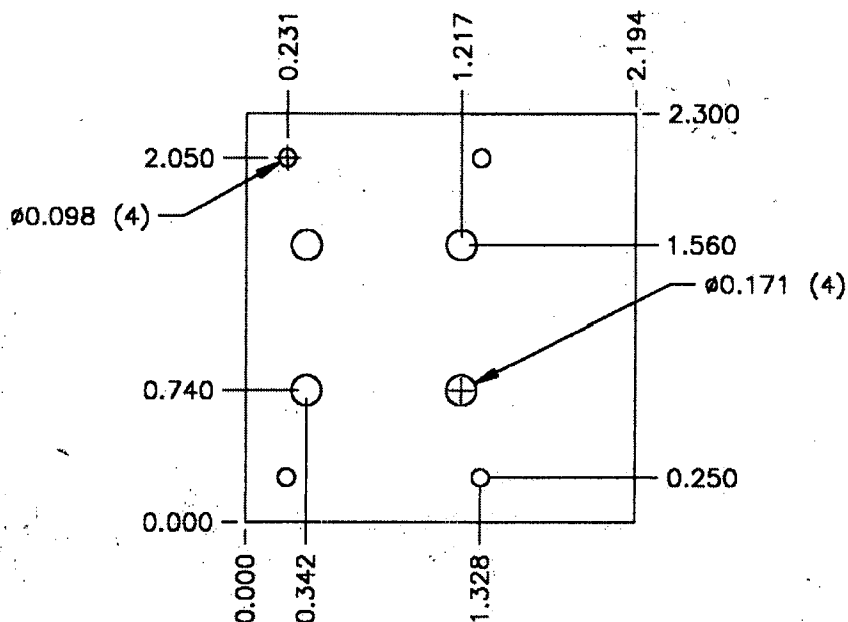
<b>Measured by:</b>		<b>Audited by:</b>		<b>Prototype Approval:</b>	N/A
<b>Date:</b>		<b>Date:</b>		<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	



DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	K HAND	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
<i>Bu</i>	<i>Bu</i>	D2151	SHEET 1 OF 1
DATE	TITLE		SCALE
95:05:01	PACKER		1:1

RELEASED  
96/06/13 BU



WORK ORDER  
NO. 25156

MATERIAL: 2024-T3, 0.040 THICK  
FINISH: WHITE POWDER COAT HI-GLOSS